

**Work Order ID 56193**

February 12, 2010 10:38:15 AM



Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *PH*Date: 10-2-12 Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr							
D3838	Rev A							
100		0.00						
Large Fab								
Large Fab	Memo	0.00						
Large Fab	1- cut D3838-1 and D3838-3 rib as per dwg D3838							
Large Fab	2- remove identification markings							
Large Fab	3- deburr							
Large Fab	4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838							
Large Fab	A/R ER316 S.S. Rod Batch: <u>M108160</u>							
Large Fab	5- c'sink hole as per dwg							
Large Fab	6- grind weld flush where indicated on dwg D3838							
Large Fab	7- weld D3759-1 bushing as per dwg D3838							
Large Fab	A/R ER316 S.S. Rod Batch: <u>M108160</u>							
Large Fab	8- grind bushing weld flush as per dwg dwg D3838							
Large Fab	9- deburr hole if necessary							

SAD 10-02-232EL 10-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56193**

Page 2

February 12, 2010 10:38:16 AM

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC9- Inspect visual per QSI004- Fusion Welds

0.00

(2)

10-02-24

QC

Memo

0.00

Quality Control

140



QC5- Inspect part completeness to step on W/O

0.00

→ S1010125

(2)

x2

-04C

QC

Memo

0.00

Quality Control

150



Identify as per dwg &amp; Stock Location: WA

0.00

SAD 10-03-01

(2)

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

# Picklist Print

Page 1

February 12, 2010 10:38:20 AM

Work Order ID: 56193



Parent Item: D3838-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 2/12/10

Required Date: 2/18/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3759-1



Manufactured

No

Each

36.0000

2.0000



EZ 10-2-23

Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA

36

53442

2

54072

9

55789

25

M304TS0.750W.065



Purchased

No

100

f 473.1552 2.1720



SAD 10-02-23

304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT

473.1552242

113082

0.00419

113245

0.00038421

113683

16.30855

113836

76.8421

113956

380

2.1720

Main Warehouse

WA

0.0000047

112398

0.0000047

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NOTE: Date & initial all entries

8

7

6

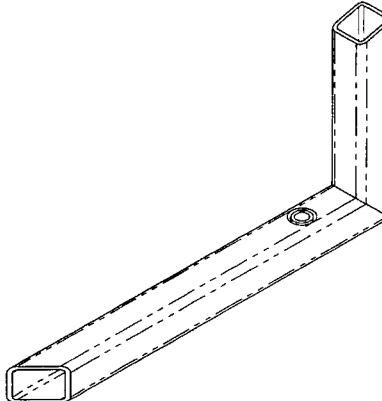
5

4

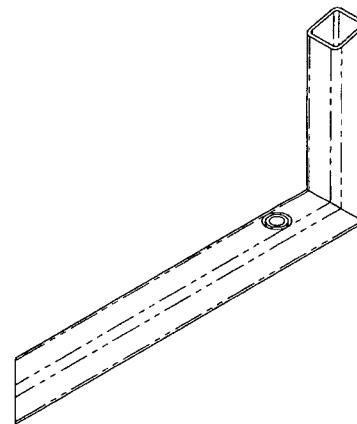
3

2

1



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 36193

*BF 10-2-12*

**RELEASED**  
*(08/11/12 JMM)*

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1</i>		
DRAWN	<i>1</i>		
CHECKED	<i>NSS</i>		
MFG. APPR.	<i>4</i>		
APPROVED	<i>1</i>		
DE APPR.	<i>1</i>		
DATE	08.10.08	SCALE	NTS

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A  
SHEET 1 OF 3

TITLE: **RIB ASSY (BASKET LID)**

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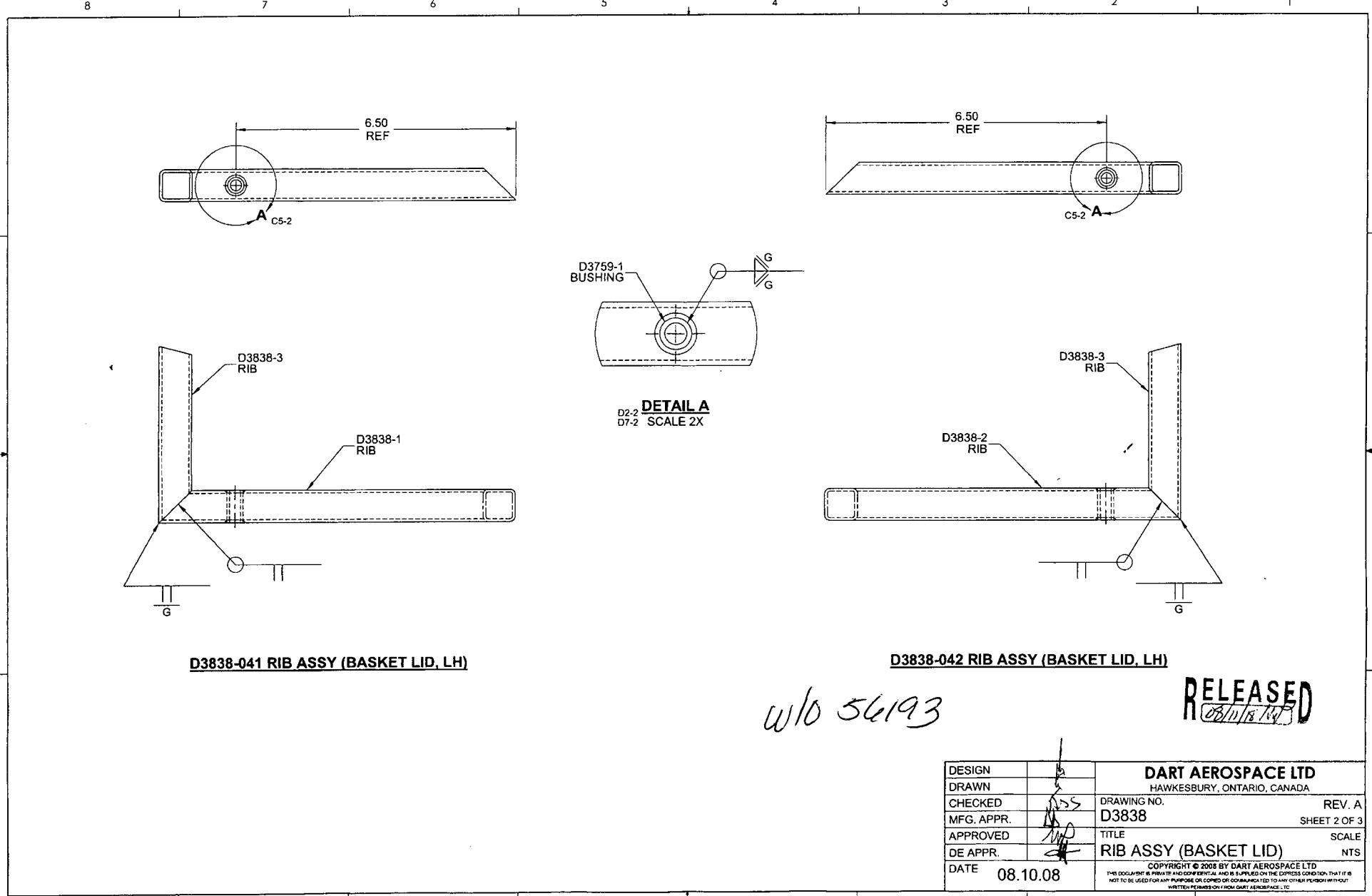
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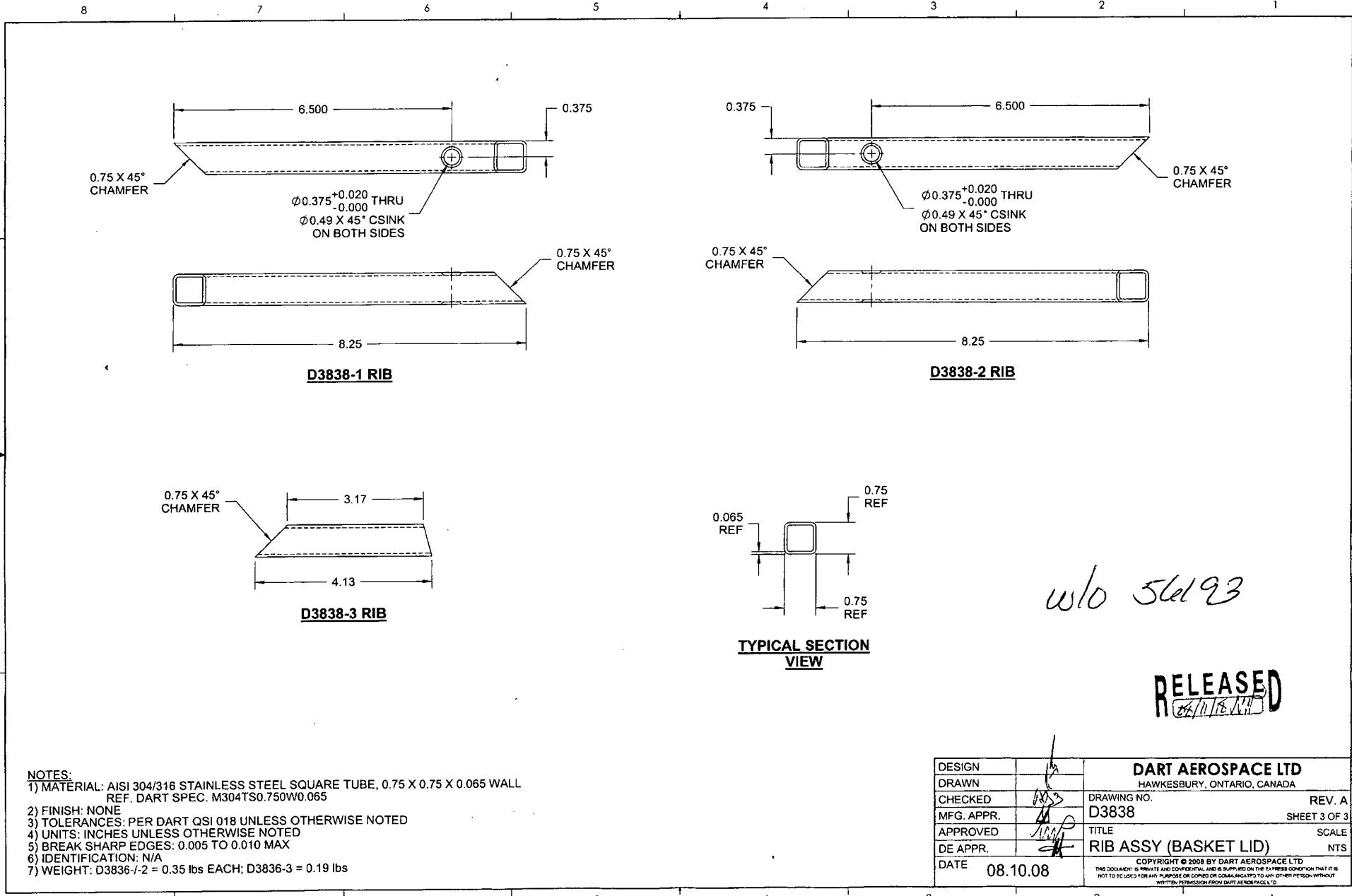


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